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D5484-041

Job Sheet 198549



Part No: D5484-041

Job Qty: 12 pcs

Part Name: Aft Cap Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/19

Job Tracking No:

Due Date: 9/13/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: IPP REV:A 17.05.26 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.03 AS PER DWG REV:A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

JOB ROUTING					Standard		Workcenter/Supplier		Lead Time	DAS Sign-off							
Op No	Operation	Qty	Start Date	Due Date	Setup Hrs	Run Hrs	Workcenter / Supplier										
100	Small Fab - 1	12 pcs	9/13/19		0.00	3.00	Small Fab - 1		58 OCT 3 0 2019 9.89								
							Small Fab - 2										
							Small Fab - 3										
							Small Fab - 4										
							Small Fab - 5										
							Small Fab - 6										
							Small Fab - 7										
							Small Fab - 8										
110	QC 5	12 pcs	9/13/19		0.00	0.00	QC 5 - 10		40 NOV 0 8 2019 9.89								
							QC 5 - 12										
							QC 5 - 17										
							QC 5 - 18										
							QC 5 - 19										
							QC 5 - 22										
							QC 5 - 24										
							QC 5 - 3										
							QC 5 - 43										
							QC 5 - 49										
							QC 5 - 51										
							QC 5 - 58										
							QC 5 - 68										
							QC 5 - 9										
							QC 5 - 50										
							QC 5 - 30										
							QC 5 - 40										
							QC 5 - 61										
							QC 5 - 81										
							120	Handfinish - 1-1 Chemical-B4B		12 pcs	9/13/19		0.00	1.20	Handfinish - 1 - 1 - B4B		BEB 19-11-09.
															Handfinish - 1 - 2 - B4B		
Handfinish - 1 - 3 -																	

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7/30/2019

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135 QC 7

12
pcs

9/13/19

0.00 0.00

B4B

Handfinish - 1 - 4 -
B4BHandfinish - 1 - 5 -
B4BHandfinish - 1 - 6 -
B4BHandfinish - 1 - 7 -
B4BHandfinish - 1 - 8 -
B4BHandfinish - 1 - 9 -
B4BHandfinish - 1 - 10 -
B4BHandfinish - 1 - 11 -
B4BHandfinish - 1 - 12 -
B4BHandfinish - 1 - 13 -
B4BHandfinish - 1 - 14 -
B4BHandfinish - 1 - 15 -
B4BHandfinish - 1 - 16 -
B4BHandfinish - 1 - 17 -
B4BHandfinish - 1 - 18 -
B4BHandfinish - 1 - 19 -
B4BHandfinish - 1 - 20 -
B4BHandfinish - 1 - 21 -
B4BHandfinish - 1 - 22 -
B4B

QC 7 - 10

QC 7 - 13

QC 7 - 14

QC 7 - 15

QC 7 - 17

QC 7 - 18

QC 7 - 19

QC 7 - 2

QC 7 - 28

QC 7 - 3

QC 7 - 30

QC 7 - 34

QC 7 - 36

QC 7 - 37

QC 7 - 41

QC 7 - 47

QC 7 - 48

QC 7 - 51

QC 7 - 58

QC 7 - 59

QC 7 - 60

QC 7 - 9

QC 7 - 68

QC 7 - 50

DAS
3

NOV 13 2019

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					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
140	Small Fab - 2 - B4B	12 pcs	9/13/19	0.00 3.00	Small Fab - 1 - B4B	DAS NOV 13 2019
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
150	QC 5	12 pcs	9/13/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	DAS
					QC 5 - 24	81
					QC 5 - 3	9-89
					QC 5 - 43	NOV 13 2019
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
M211886	160 Powdercoat - 1 White GI(A)- B4B	12 pcs	9/13/19	0.00 3.00	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-11-13
					Powdercoat - 4 - B4B	
START: 11:00	170 QC 3	12 pcs	9/13/19	0.00 0.00	QC 3 - 10	
W.T. 3:30					QC 3 - 13	
FINISH 11:30					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	DAS NOV 13 2019
					QC 3 - 9	68
					QC 3 - 40	9-89
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	

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				QC 3 - 81	
180 Packaging 3-1 - Stock - B4B	12 pcs	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	BEB 19-11-13.
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	12 pcs	9/13/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS NOV 13 2019
21
9:59

Part Op 100 - 1- Drill and C'sink rivet holes as per dwg Use DT10343 2- Deburr
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 135 - (QC7-Inspect Chemical Conversion Coat)
 140 - Install nut plates as per dwg
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), ***HAND TIGHT A SCREW IN THE NUTPLATE PRIOR TO
 POWDERCOAT*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
 170 - QC3- Inspect Part Finish Standard Process
 180 - (Identify as per dwg & Stock Location: EP001)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-04	Nutplate Rivet	48 Ea (4 ea)	100-Small Fab - 1	5020767
D5484-1	Aft Cap	12 pcs (1 ea)	100-Small Fab - 1	5157070
MS21075L3N	Nut Plate	24 Ea (2 ea)	100-Small Fab - 1	5048407

CC0004
GA034
5298

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	CCR264SS-3-04	48	61	0
	D5484-1	12	23	0
	MS21075L3N	24	44	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

MRB (QS1042)

Date: _____ Sequence #: _____

QTY Affected: _____

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

Pressure/Forced ☐ ☐ ☐
Bending ☐ ☐ ☐
Crushing ☐ ☐ ☐
Cracks ☐ ☐ ☐
Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐
Mislabeled ☐ ☐ ☐

Contamination ☐ ☐ ☐
Misaligned/off center ☐ ☐ ☐
BOM/Route ☐ ☐ ☐
Broken/Damage/Defect ☐ ☐ ☐
Incomplete/Unclear Instructions ☐ ☐ ☐
Drill Holes ☐ ☐ ☐
Fit/Function ☐ ☐ ☐

FAULT CATEGORY

Power Loss/Surge ☐ ☐ ☐
Folio/Program ☐ ☐ ☐
Grain Direction ☐ ☐ ☐
Weld ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐

Positioned Wrong ☐ ☐ ☐
Outside Tolerance ☐ ☐ ☐
Drawing ☐ ☐ ☐
Finish ☐ ☐ ☐
Part Lost/Missing ☐ ☐ ☐
Misread ☐ ☐ ☐

Other/Details: _____